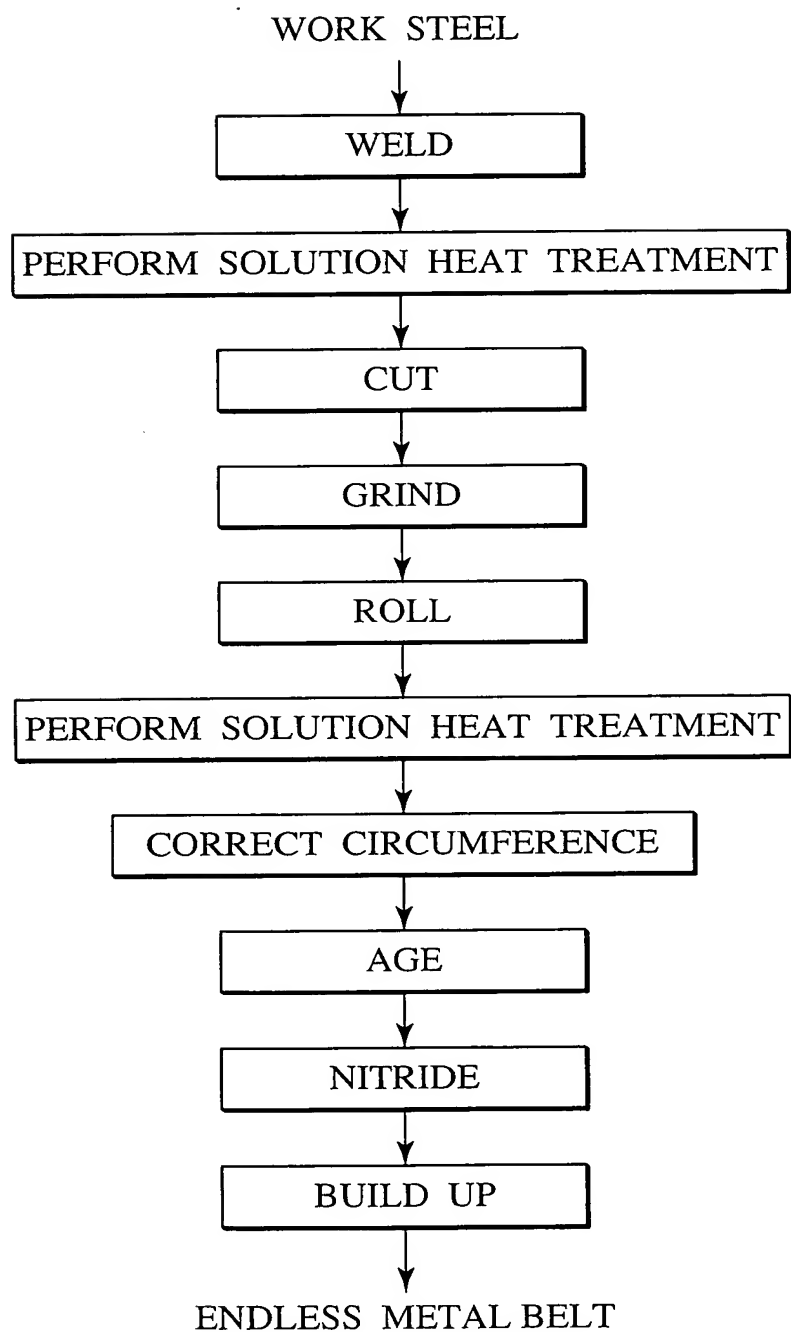


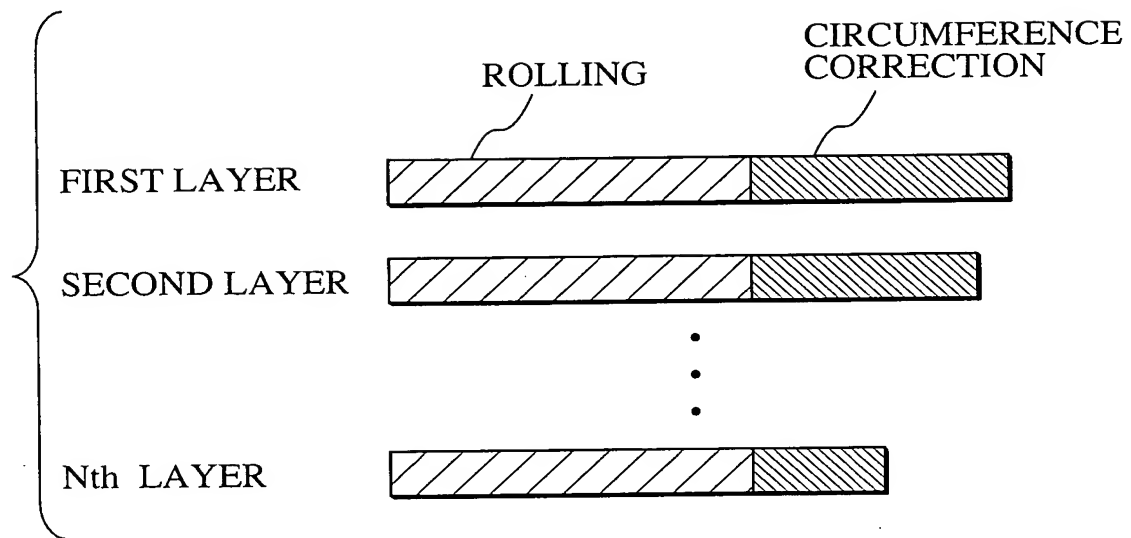
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FIG. 1



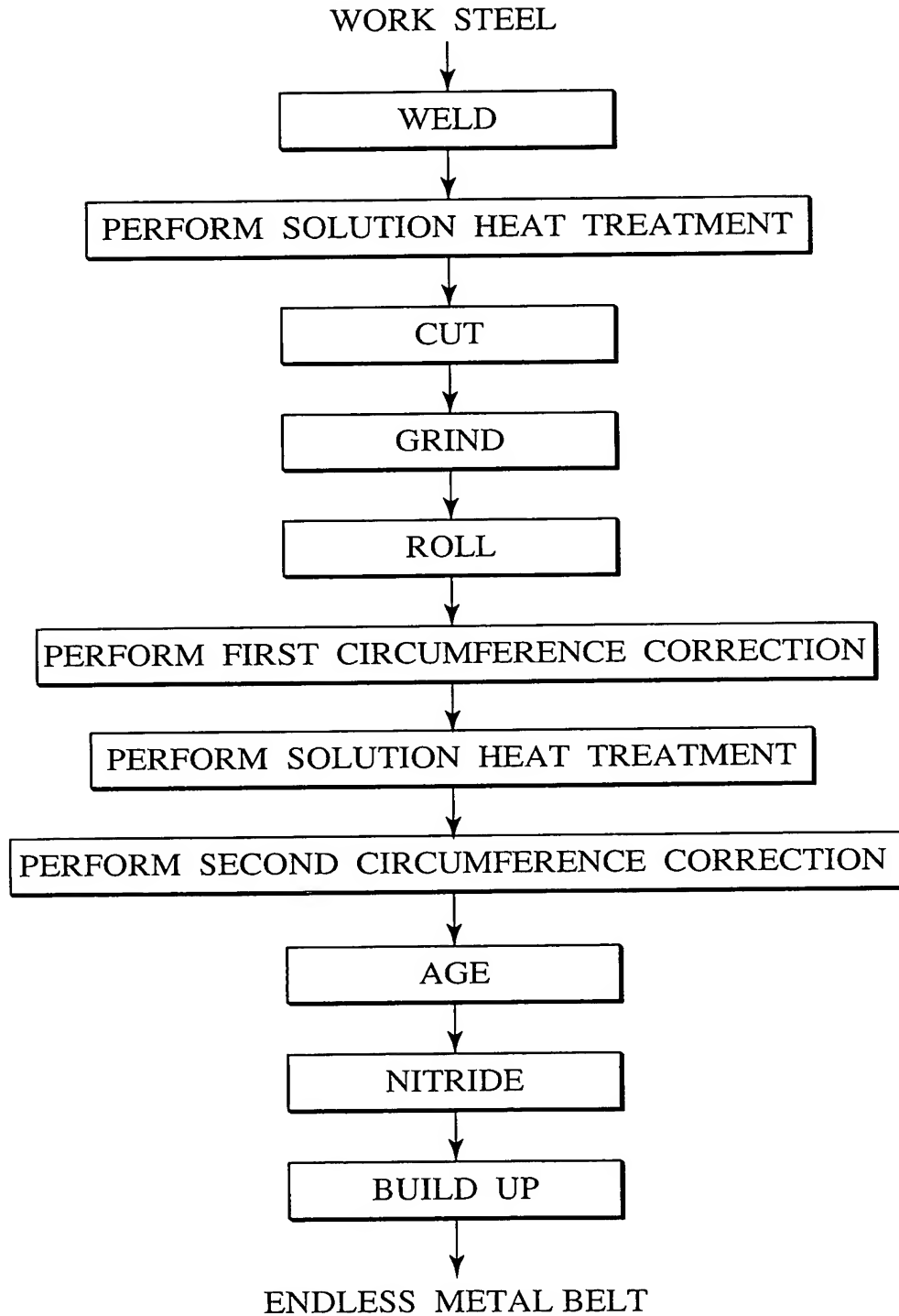
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FIG. 2



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FIG. 3



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FIG. 4

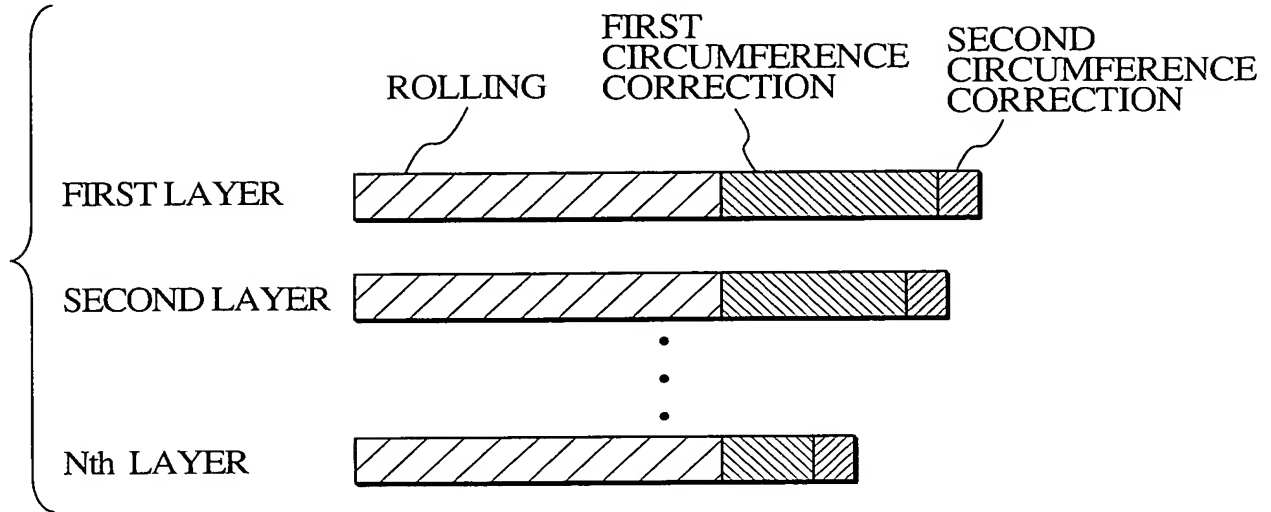
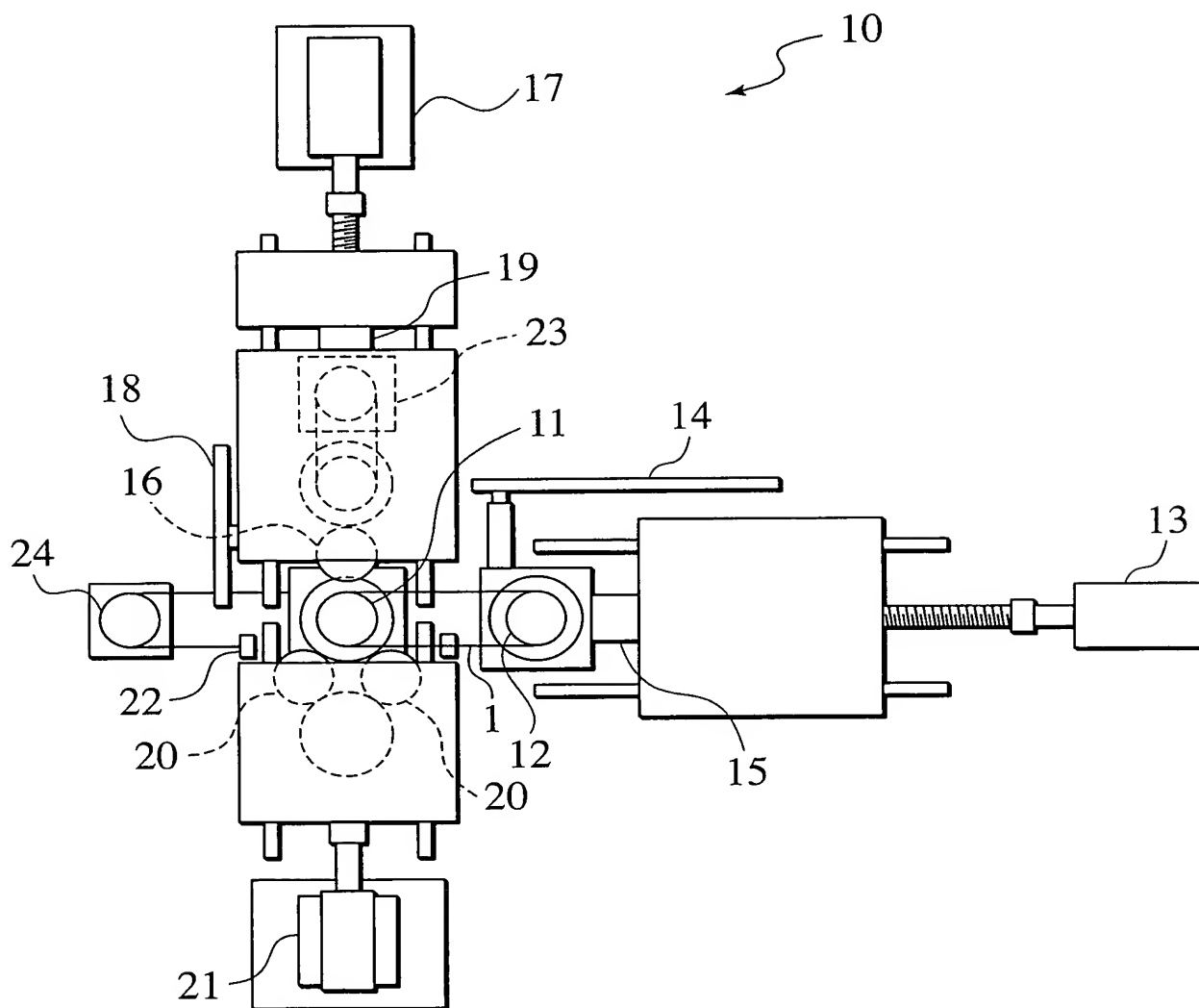


FIG. 5

	LAYER	CIRCUMFER- ENCE (mm)	THICKNESS (mm)	CORRECTION QUANTITY (mm)
BEFORE ROLLING STEP	1	430.00	0.30	
	2	430.00	0.30	
	3	430.00	0.30	
	4	430.00	0.30	
	5	430.00	0.30	
AFTER ROLLING STEP	1	700.00	0.19	
	2	700.00	0.19	
	3	700.00	0.19	
	4	700.00	0.19	
	5	700.00	0.19	
AFTER FIRST CIRCUMFERENCE CORRECTION STEP	1	705.00	0.18	5.00
	2	706.00	0.18	6.00
	3	707.00	0.18	7.00
	4	708.00	0.18	8.00
	5	709.00	0.18	9.00
AFTER SECOND CIRCUMFERENCE CORRECTION STEP	1	710.00	0.18	1.00
	2	711.00	0.18	1.00
	3	712.00	0.18	1.00
	4	713.00	0.18	1.00
	5	714.00	0.18	1.00

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FIG. 6



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FIG. 7

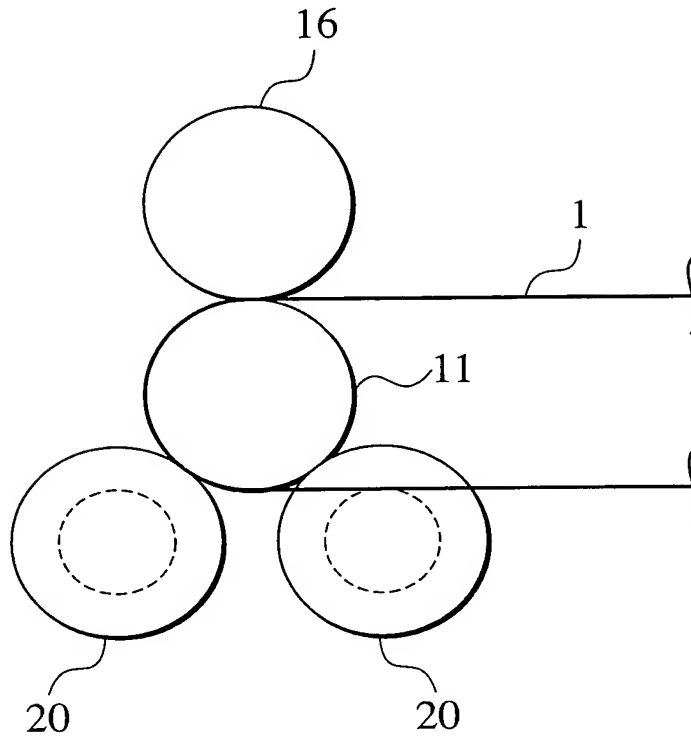
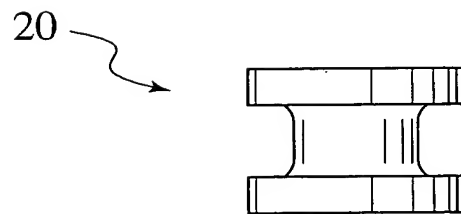


FIG. 8



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FIG. 9A

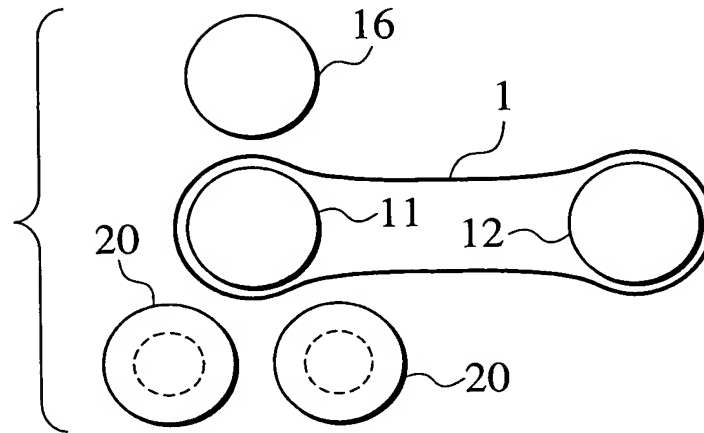


FIG. 9B

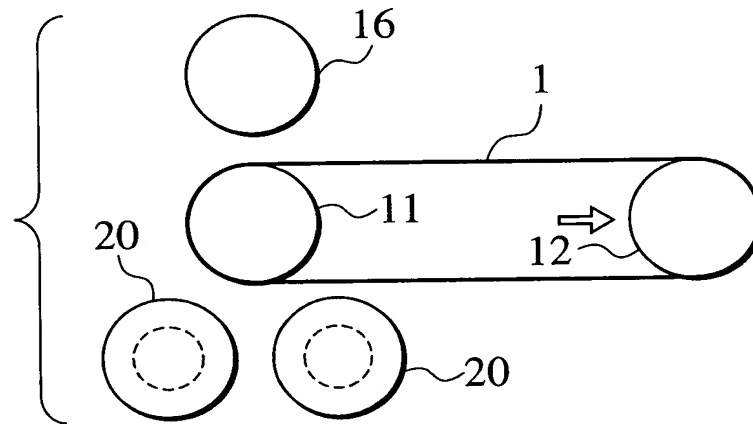
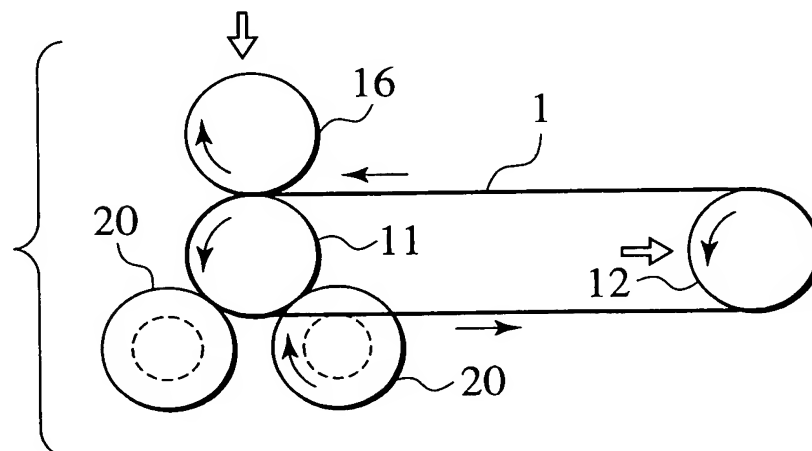
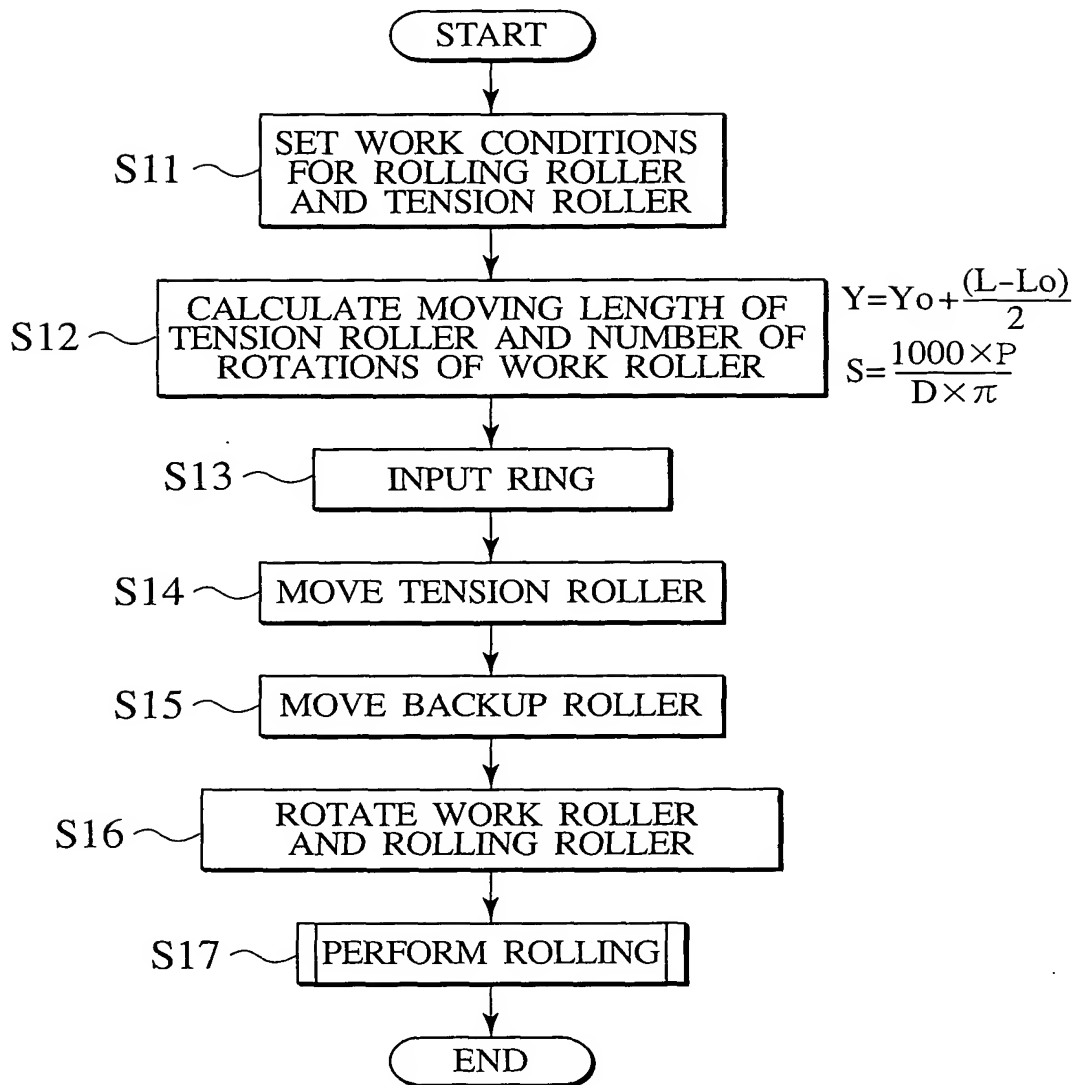


FIG. 9C



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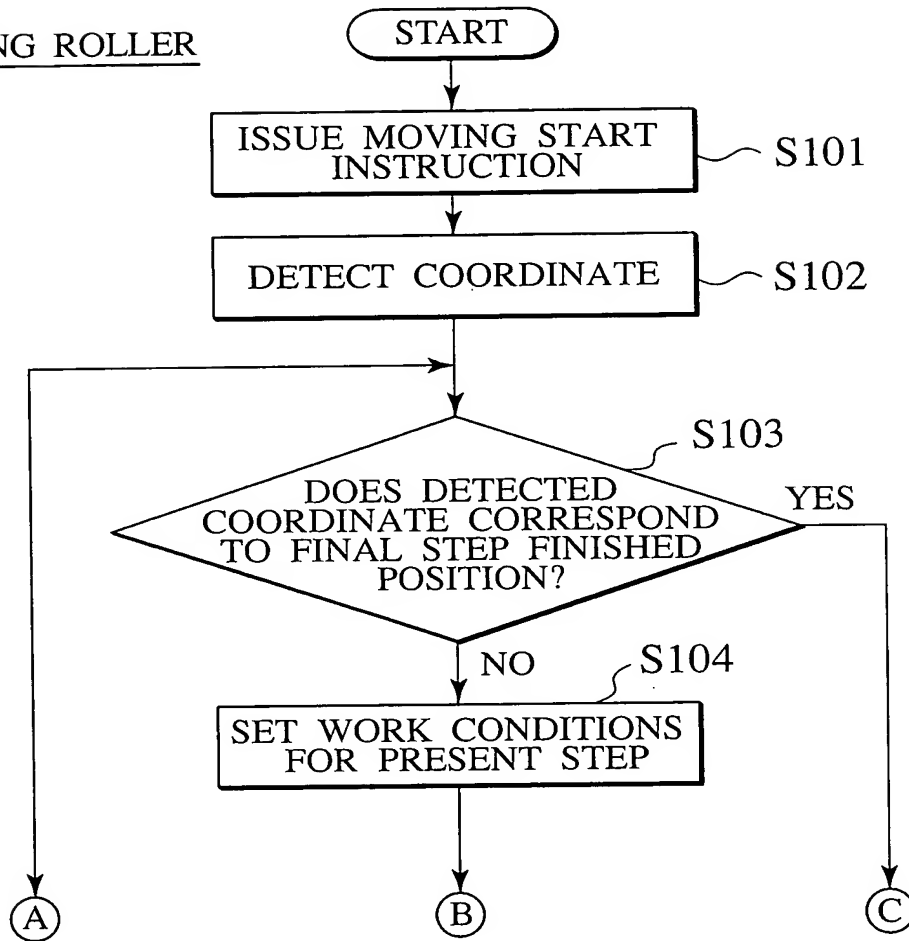
FIG. 10



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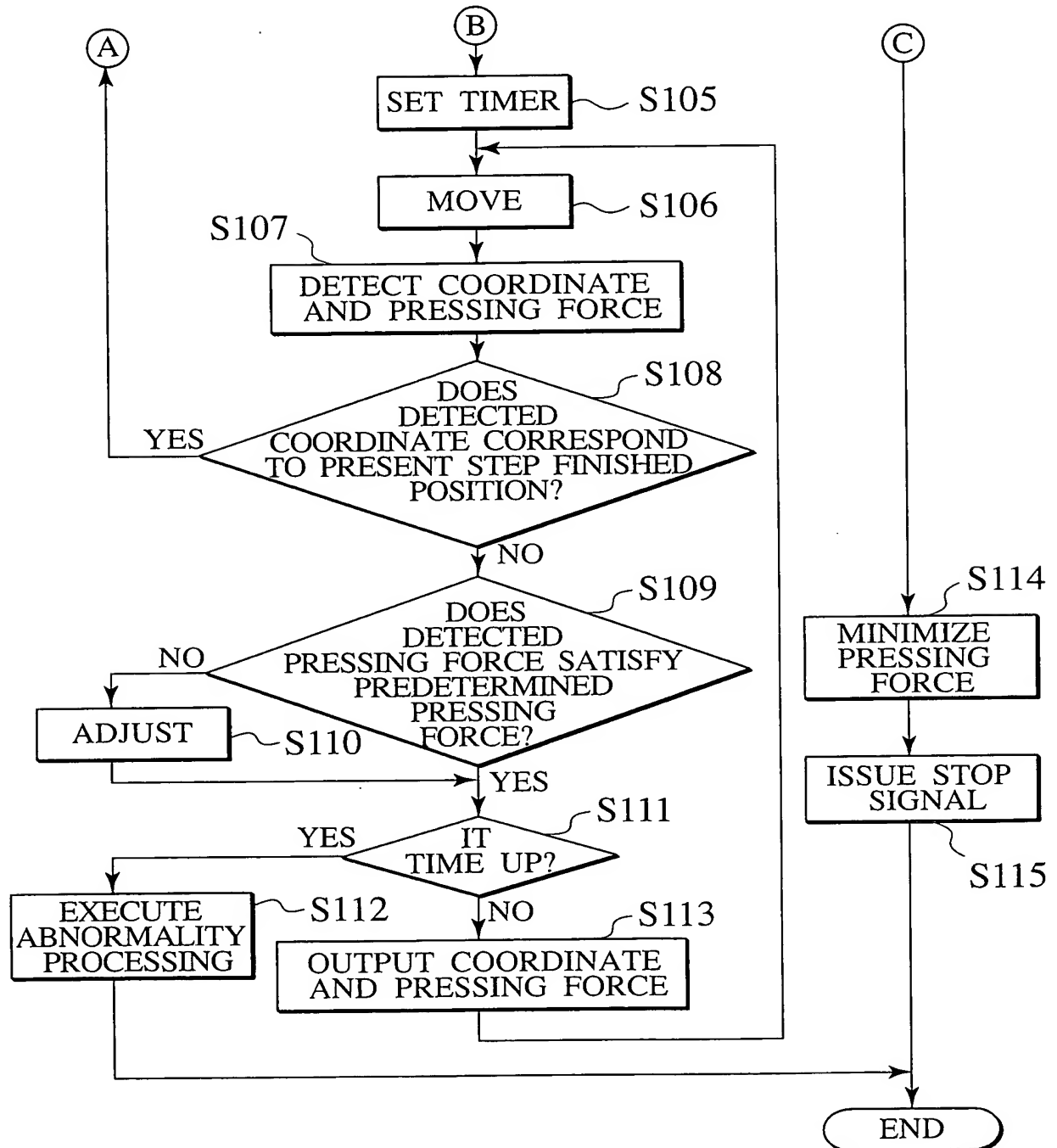
FIG. 11

ROLLING ROLLER



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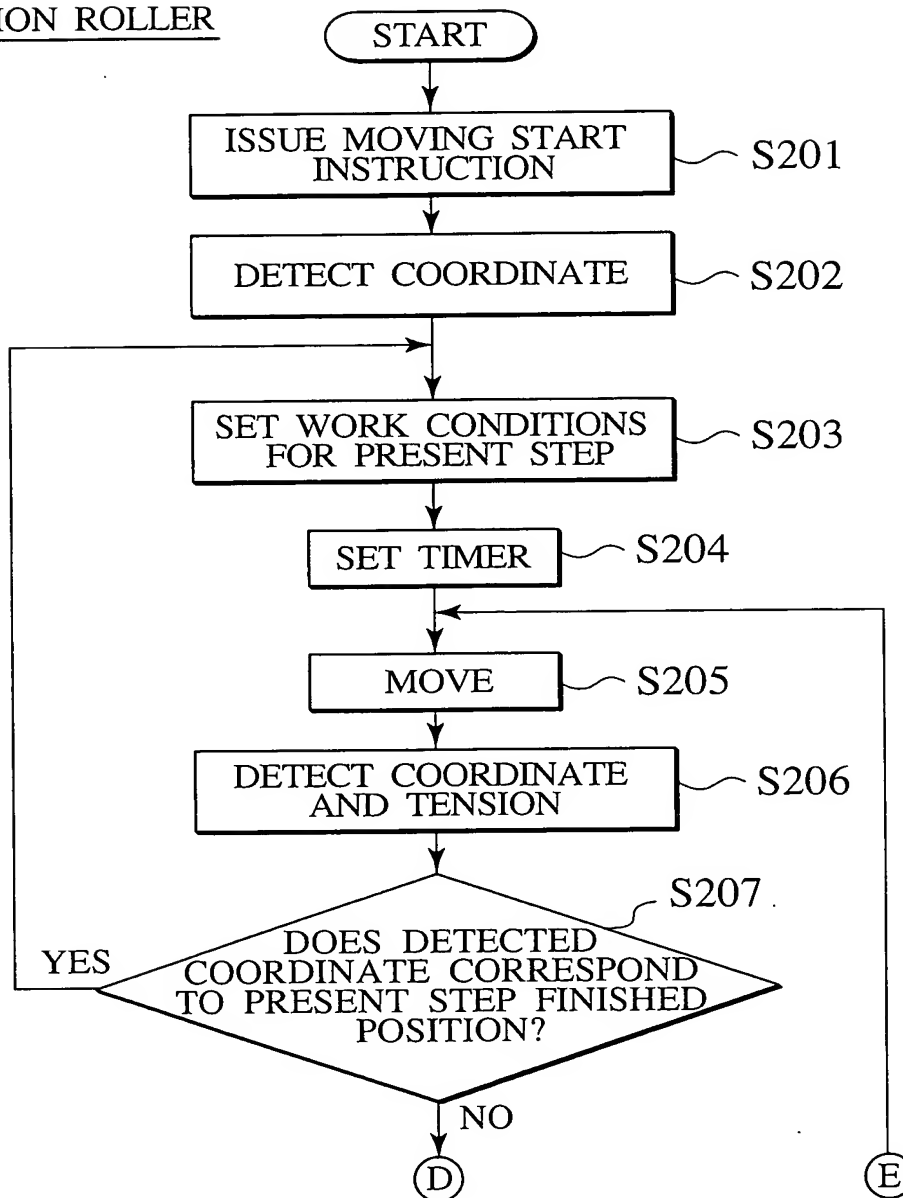
FIG. 12



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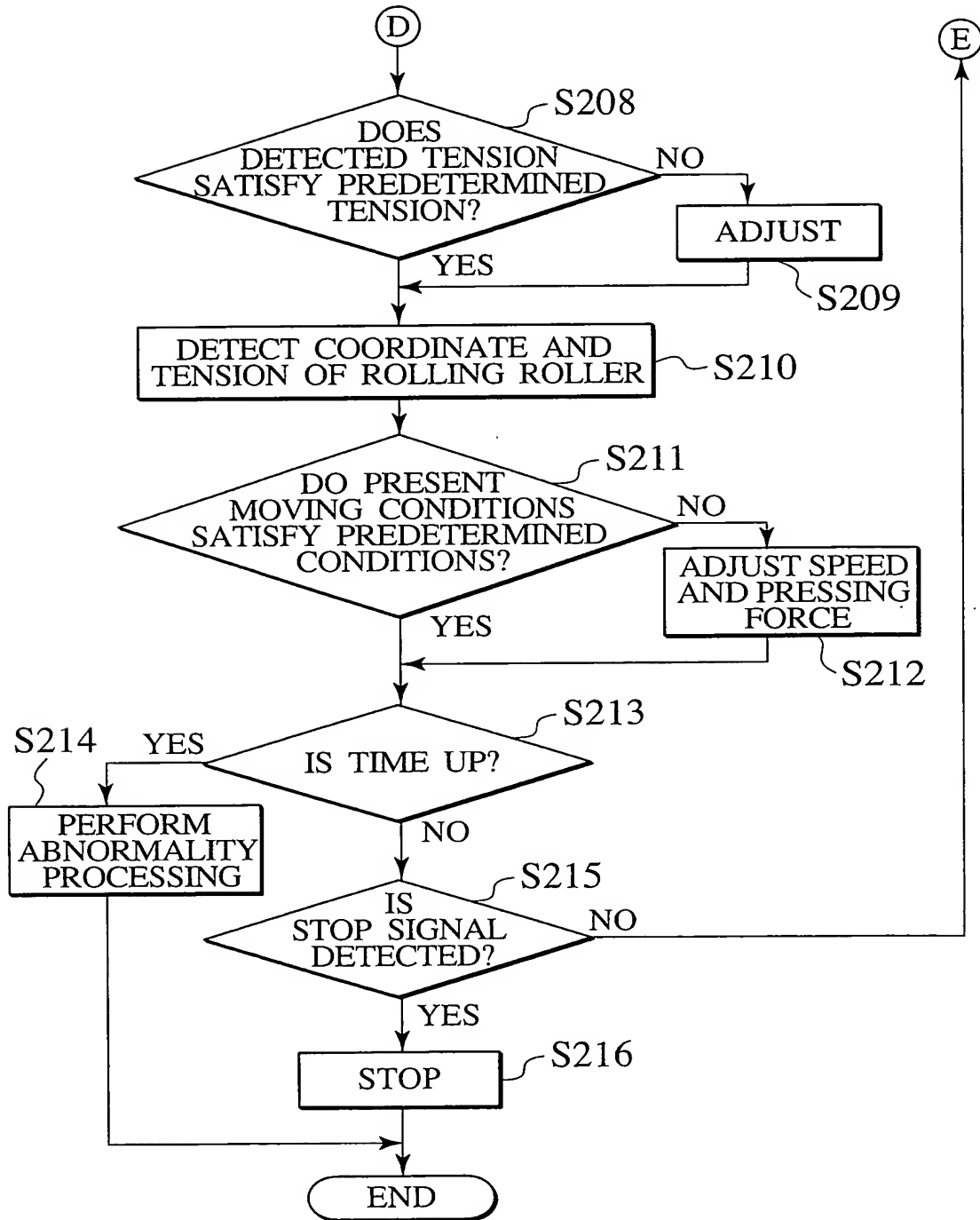
FIG. 13

TENSION ROLLER



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FIG. 14



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FIG. 15A

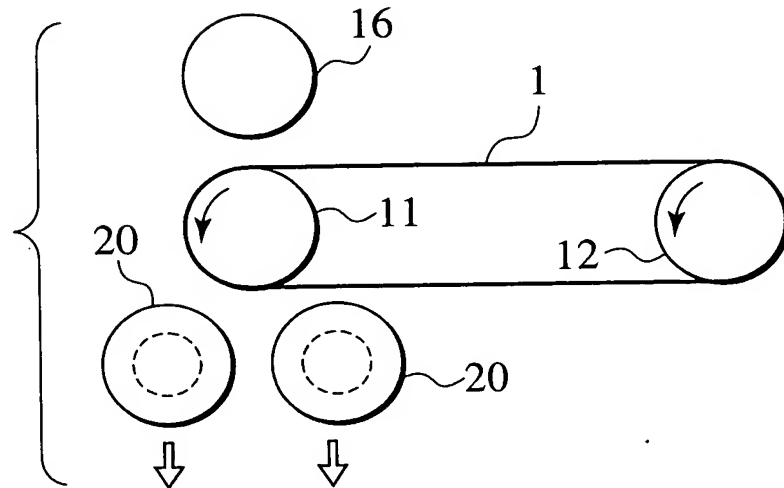


FIG. 15B

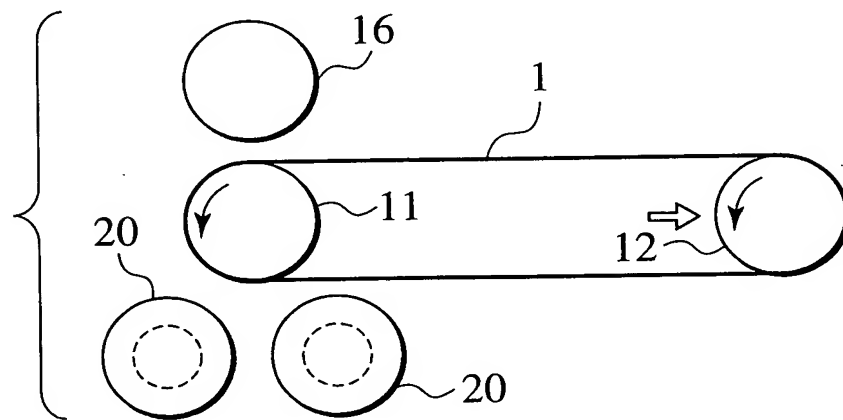
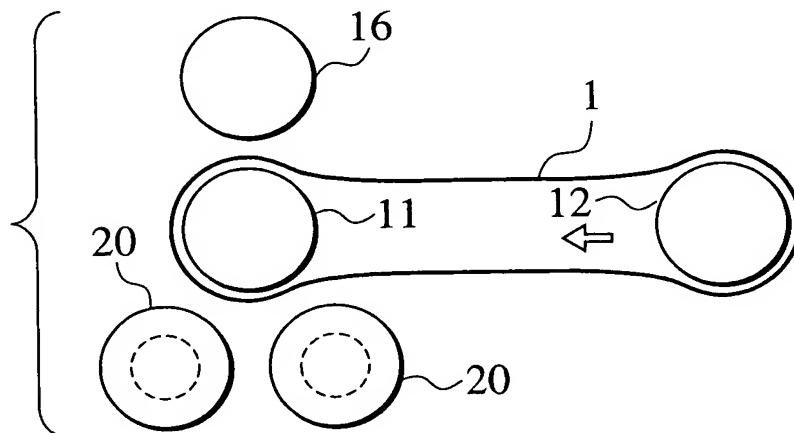
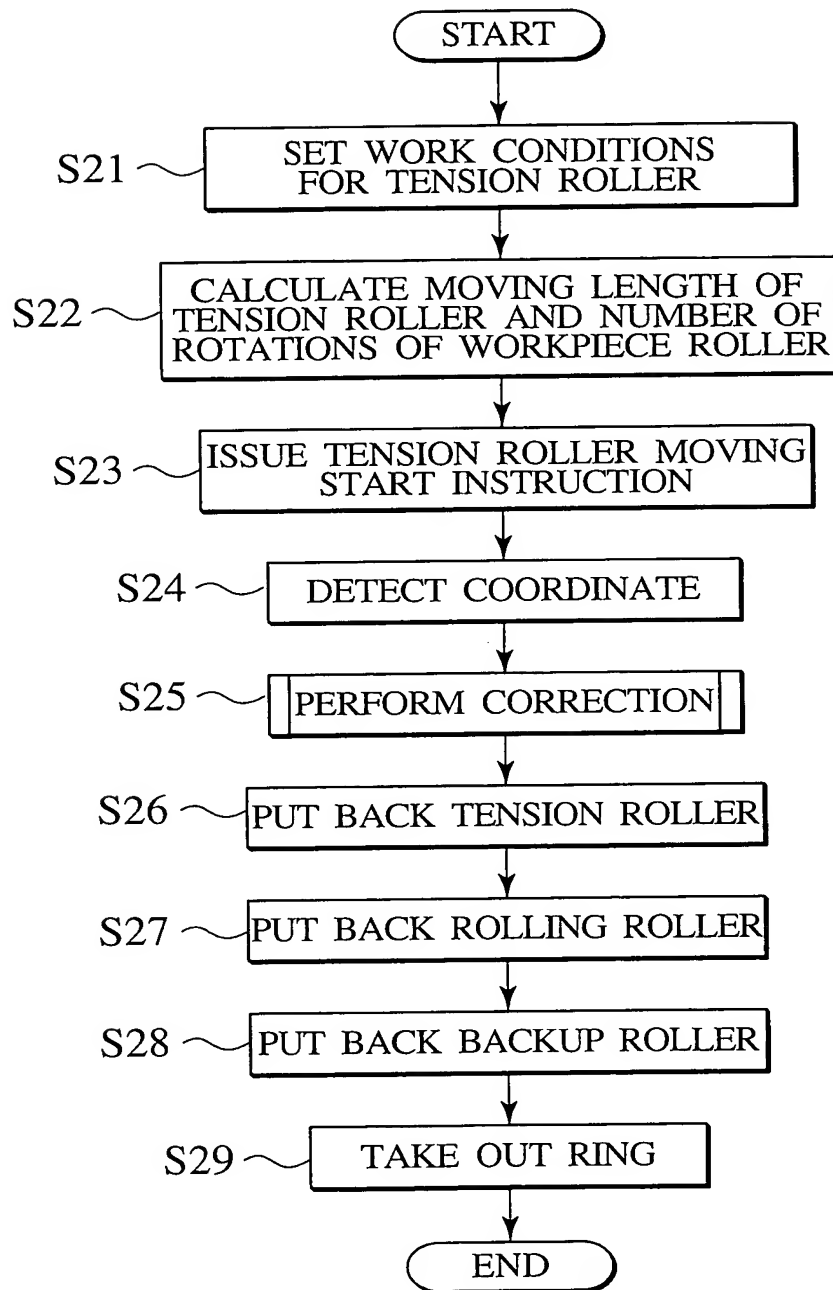


FIG. 15C

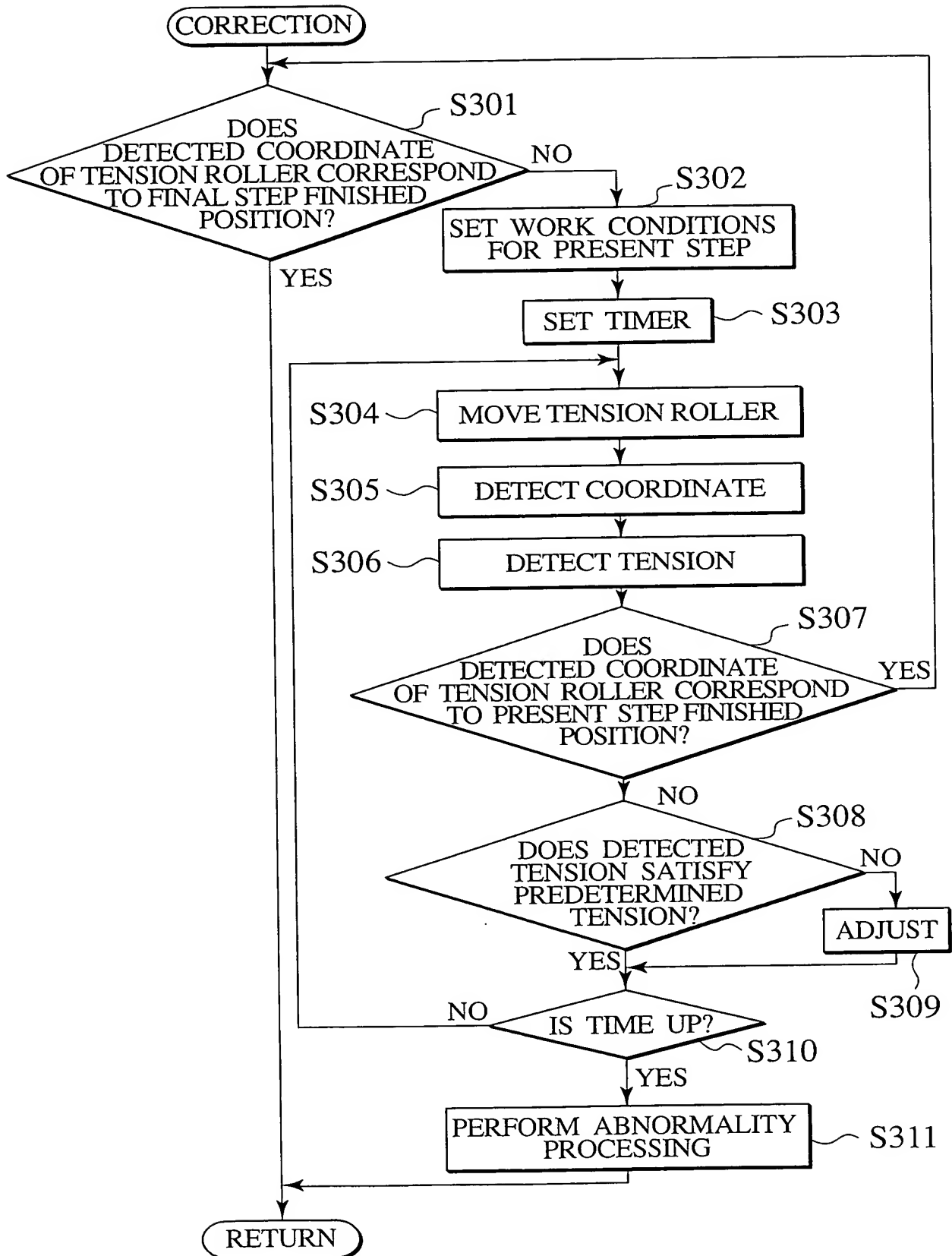


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FIG. 16

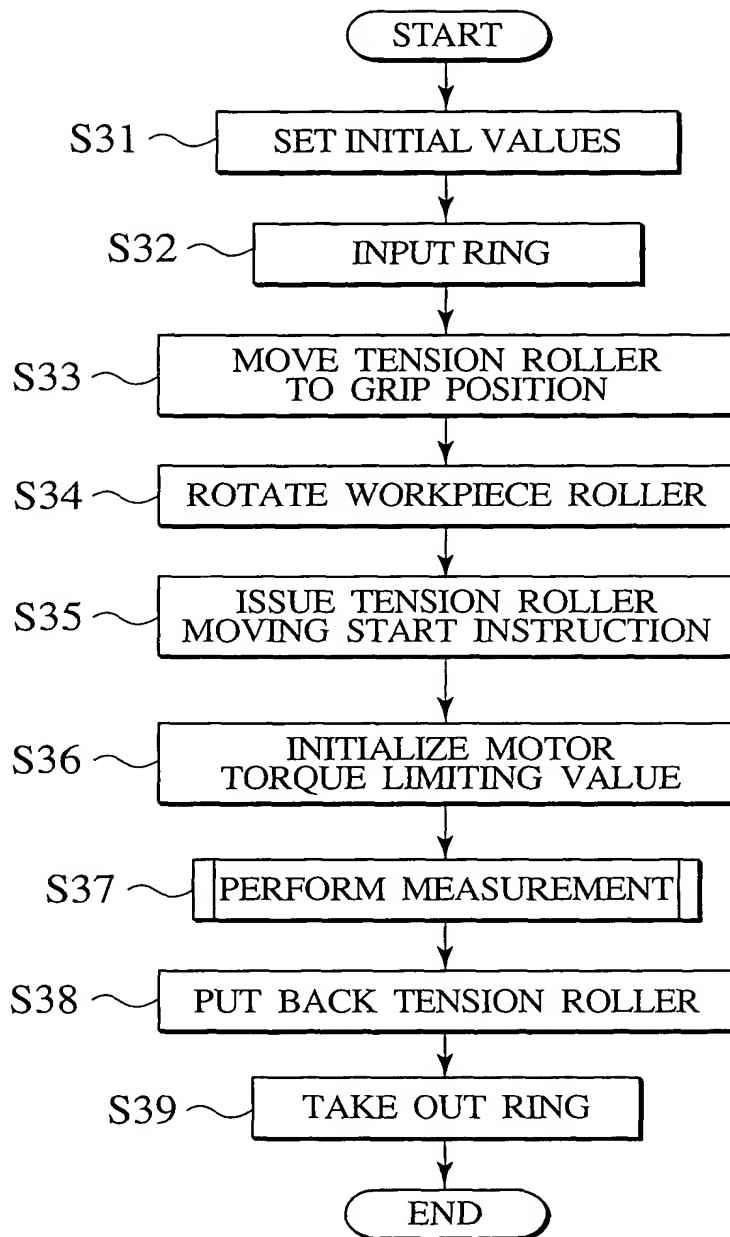


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FIG. 17



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FIG. 18



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FIG. 19

